

Work Order ID 79985

79985

Page 1

Wednesday, February 08, 2012 3:07:21 PM

Item ID: D4055-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fuel Tank Assembly

Start Date: 2/8/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/2/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 12-02-09 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4055 | B |

100 Weld per dwg A/R Aluminum rod Batch: 119112 0.00

100

Large Fab

Large Fab

Memo

0.00

1- weld D4023-3 cap, D3999-11 earth tab and D4008-11 hinge onto D4055-11 as per dwg D4055

2- Weld D4001-1 and D4000-5 onto D4055-1 Top

2- Weld D4055-9 and D4055-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg, Weld D4055-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5-Weld D4055-7 fwd end

12-02-21

1

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

1 0 BE 12/02/22

121

Weld per dwg A/R Aluminum rod Batch **120169** 0.00

121

Large Fab

Memo

0.00

Large Fab

1-Weld top D4055-1

12-02-28

1 0

122

QC9- Inspect visual per QSI004- Fusion Welds 0.00

122

QC

Memo

0.00

Quality Control

1 0 BE 12/02/28

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

123

QC5- Inspect part completeness to step on W/O

0.00

123

QC

Quality Control

Memo

Pressure Test as per dwg D4055

- Pressure tested at 4.5psi 15min
- Filled with water, no leaks

0.00

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Hand Finishing

Memo

1- brush alodine on tank. No alodine inside

0.00

140

Inspect Chemical Conversion Coat

0.00

140

QC

Quality Control

Memo

0.00

12-2-28 } - Sublet 28

1 2/28 12/03/01

1X2 m/l 12/03/01

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Cust Item ID:

Required Date: 3/2/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Grey AWS161

Set Up/
Run Hours

| Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---------|--------|-----------|------------|------------|---------------|-------------|
|---------|--------|-----------|------------|------------|---------------|-------------|

170

Grey Sandtex (Ref: 4.3.5.6) per QSI005 4.3

0.00

170

Powdercoat

PS311 A13

Memo

0.00

Powder Coating

****Mask prior to powdercoat****

Start Time: *11-00*

Oven Temperature: *320 OF*

Finish Time: *11-30*

1X2 m-1 12/03/01

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

1 BL 12 3-1

185

0.00

185

SprayPaint

Memo

0.00

Spray Painting

Seal inside of tank using Sloshing

PR-1005-1

Sealer as per dwg

u/AS

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Cust Item ID:

Required Date: 3/2/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

190

Small Fab

Small Fab

Memo

Assemble as per dwg & DSI 9577

0.00

0.00

12/13/05 (U)

220

220

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

5/17/03/05

(U)

230

230

Packaging

Packaging

Identify as per dwg & Stock Location: _____

Memo

PPA 79985 0.00

0.00

6/13/05 (U)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Work Order ID 79985***79985***

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Fuel Tank Assembly

Stop ***NS2***Start Date: 2/8/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/2/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

| Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---------|--------|-----------|------------|------------|---------------|-------------|
|---------|--------|-----------|------------|------------|---------------|-------------|

240

QC21- Final Inspection - Work Order Release

0.00

240

QC

Memo

0.00

Quality Control

12/3/5
MF
12-03-05

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, February 08, 2012 3:07:19 P

Page 1

Work Order ID: 79985
Parent Item: D4055-041
Parent Item Name: Fuel Tank Assembly

Start Date: 2/8/2012

Required Date: 3/2/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 10.03.08 new issue prelim EC verified by:DD IPP Rev:B 10.05.17 ECN10-562
DD verf:EC IPP Rev C: 10.11.23 revised pick list EC verified by:DD
IPP Rev D: 11.06.01 per D4055 revB EC verified by:DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D3997-1 Placard | | Manufactured | No | | | 190 | Each | 6.0000 | 1 | 1 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST082 | | 6 | | | | | | | |
| | | | | 79411 | | 6 | | | | | | | |
| D3997-5 Placard | | Manufactured | No | | | 190 | Each | 3.0000 | 2 | 2 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST104 | | 93 | | | | | | | |
| | | | | 72611 | | 93 | | | | | | | |
| D3997-11 Placard | | Manufactured | No | | | 190 | Each | 3.0000 | 1 | 1 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST104 | | 3 | | | | | | | |
| | | | | 73510 | | 3 | | | | | | | |
| D3997-17 Placard | | Manufactured | No | | | 190 | Each | 5.0000 | 1 | 1 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST104 | | 5 | | | | | | | |
| | | | | 73513 | | 5 | | | | | | | |
| D3997-29 Placard | | Manufactured | No | | | 190 | Each | 5.0000 | 1 | 1 | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST104 | | 5 | | | | | | | |
| | | | | 73511 | | 5 | | | | | | | |

79411

72611

80308

80309

80845

| W/O: | | WORK ORDER CHANGES | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 79985

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 2/8/2012

Required Date: 3/2/2012

Start Qty: 1.00

Required Qty: 1.00

D3997-43 Manufactured No 190 Each 3.0000 1 1 80310 *CR*

Placard

Location Loc Qty Loc Code

ST104 3

73512 3

✓ D3999-7

Manufactured No

100 Each 14.0000

Corner

1 1

12.02.15

Location Loc Qty Loc Code

WA014 14

71695 1

75156 13

✓ D3999-9

Manufactured No

100 Each 4.0000

Angle

1 1

12.02.15

Location Loc Qty Loc Code

WA014 4

71696 4

✓ D3999-11

Manufactured No

100 Each 6.0000

Earth Tab

1 1

12.02.15

Location Loc Qty Loc Code

WA 8

WA013 -8

WA014 6

75180 6

✓ D3999-041

Manufactured No

100 Each 3.0000

Baffle Assembly, Aft

1 1

12.02.15

Location Loc Qty Loc Code

WA014 3

75230 3

Wednesday, February 08, 2012 3:07:20 PM

Shop Packet Print

Page 2

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 2/8/2012

Required Date: 3/2/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D3999-043 Manufactured No 100 Each 4.0000 1 1 *12.02.15*
Baffle Assembly, Fwd

Location Loc Qty Loc Code

WA 4

78814 4

✓ D4000-1 Manufactured No 100 Each 2.0000 1 1 *12.02.22*
Fuel Supply Fitting

Location Loc Qty Loc Code

WA014 *B80029* 2

74835 2

✓ D4000-5 Manufactured No 100 Each 2.0000 1 1 *12.02.21*
Fuel Tank Vent Fitting

Location Loc Qty Loc Code

WA014 *B80030* 2

74833 2

✓ D4000-9 Manufactured No 100 Each 18.0000 3 3 *12.02.15*
Grommet

Location Loc Qty Loc Code

WA013 18

78379 18

✓ D4000-043 Manufactured No 100 Each 3.0000 1 1 *12.02.15*
Drain Fitting Assembly, Fwd

Location Loc Qty Loc Code

WA 3

78181 1

78732 2

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Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 2/8/2012

Required Date: 3/2/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D4000-045 Manufactured No 100 Each 4.0000
Fuel Pickup Fitting Assembly

| Location | Loc Qty | Loc Code |
|------------------|---------|----------|
| WA <u>B80036</u> | 1 | |
| 78756 | 1 | |
| WA013 | 1 | |
| 72078 | 1 | |
| WA014 | 2 | |
| 71669 | 1 | |
| 78266 | 1 | |

1 1

12.02.15

✓ D4000-041 Manufactured No 100 Each 1.0000
Drain Fitting Assembly, Aft

| Location | Loc Qty | Loc Code |
|------------------|---------|----------|
| WA <u>B80034</u> | 1 | |
| 78182 | 1 | |

1 1

12.02.15

✓ D4001-1 Manufactured No 100 Each 2.0000
Fitting

| Location | Loc Qty | Loc Code |
|---------------------|---------|----------|
| WA014 <u>B80031</u> | 2 | |
| 74831 | 2 | |

1 1

12.02.21

✓ D4008-11 Manufactured No 100 Each 2.0000
Hinge Half

| Location | Loc Qty | Loc Code |
|--------------|---------|----------|
| WA014 | 2 | |
| <u>75228</u> | 2 | |

1 1

12.02.15

D4008-041 Manufactured No 190 Each 4.0000
Fuel Filler Splash Guard Assembly

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST108 | 4 | |
| 72792 | 4 | |

1 1

72792

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Shop Packet Print

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Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 2/8/2012

Required Date: 3/2/2012

Start Qty: 1.00

Required Qty: 1.00

| | | | | | | | | | |
|-----------------------|--------------|----|-----------------|----------------|------|-----------------|---|---|----------|
| ✓ D4023-3 | Manufactured | No | | 100 | Each | 4.0000 | 1 | 1 | 12.02.15 |
| Cap and Flange | | | | | | | | | |
| | | | <u>Location</u> | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | ST110 | 4 | | | | | |
| | | | 73514 | 4 | | | | | |
| D4025-1 | Manufactured | No | | 100 | Each | 3.0000 | 1 | 1 | 80033 |
| Fuel Quantity Sender | | | | | | | | | |
| | | | <u>Location</u> | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | ST141a | 3 | | | | | |
| | | | 71765 | 3 | | | | | |
| ✓ D4055-11 | Manufactured | No | | 100 | Each | 3.0000 | 1 | 1 | 12.02.15 |
| Tank Front and Bottom | | | | | | | | | |
| | | | <u>Location</u> | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | WA014 | 3 | | | | | |
| | | | 74908 | 3 | | | | | |
| ✓ D4055-9 | Manufactured | No | | 100 | Each | 2.0000 | 1 | 1 | 12.02.22 |
| Tank Back | | | | | | | | | |
| | | | <u>Location</u> | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | WA014 | 2 | | | | | |
| | | | 75125 | 2 | | | | | |
| ✓ D4055-7 | Manufactured | No | | 100 | Each | 1.0000 | 1 | 1 | 12.02.22 |
| Tank Fwd End | | | | | | | | | |
| | | | <u>Location</u> | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | WA014 B73441 | 1 | | | | | |
| | | | 74955 | 1 | | | | | |
| * D4055-5 | Manufactured | No | | 100 | Each | 5.0000 | 1 | 1 | 12.02.21 |
| Tank Upper Cut Out | | | | | | | | | |
| | | | <u>Location</u> | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | WA014 B73476 | 5 | | | | | |
| | | | 74907 | 5 | | | | | |

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Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 79985

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 2/8/2012

Required Date: 3/2/2012

Start Qty: 1.00

Required Qty: 1.00

| | | | | | | | | |
|----------------|--------------|-----------------|----------------|-----------------|------------|---|---|----------|
| ✓ D4055-3 | Manufactured | No | 100 | Each | 5.0000 | 1 | 1 | 12-02-22 |
| Tank Aft End | | | | | | | | |
| | | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> | | | | |
| | | WA014 | 5 | | | | | |
| | | 73475 | 1 | | | | | |
| | | 75224 | 4 | | | | | |
| ✓ D4055-1 | Manufactured | No | 100 | Each | 7.0000 | 1 | 1 | 12-02-21 |
| Tank Top | | | | | | | | |
| | | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> | | | | |
| | | WA013 | 7 | | | | | |
| | | 78380 | 3 | | | | | |
| | | 78820 | 4 | | | | | |
| ✓ D4057-1 | Manufactured | No | 100 | Each | 14.0000 | 3 | 3 | 12-02-15 |
| Retaining Ring | | | | | | | | |
| | | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> | | | | |
| | | WA013 | 14 | | | | | |
| | | 71166 | 14 | | | | | |
| AN3H5A | Purchased | No | 190 | Each | 22.0000 | 5 | 5 | |
| Bolt | | | | | | | | |
| | | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> | | | | |
| | | ST351 | 22 | | | | | |
| | | 116704 | 1 | | | | | |
| | | 118112 | 11 | | | | | |
| | | 120498 | 10 | | | | | |
| NAS1149D0363J | Purchased | No | 190 | Each | 2,655.0000 | 5 | 5 | |
| Washer | | | | | | | | |
| | | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> | | | | |
| | | ST298 | 2655 | | | | | |
| | | 117601 | 61 | | | | | |
| | | 118077 | 1 | | | | | |
| | | 118612 | 18 | | | | | |
| | | 119537 | 899 | | | | | |
| | | 120142 | 676 | | | | | |
| | | 120308 | 1000 | | | | | |

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Dart Aerospace Ltd

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Picklist Print

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Work Order ID: 79985

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 2/8/2012

Required Date: 3/2/2012

Start Qty: 1.00

Required Qty: 1.00

D4404-1 Manufactured No 190 Each 7.0000 1 1 — E
Cushion

Location Loc Qty Loc Code

ST242A 7

75181 7

D4404-5 Manufactured No Each 5.0000
Cushion, Fwd

Location Loc Qty Loc Code

ST242A 5

76899 5

D4404-7 Manufactured No Each 7.0000
Cushion, Upper Side

Location Loc Qty Loc Code

ST242A 7

79119 7

D4404-9 Manufactured No Each 7.0000
Cushion, Lower Side

Location Loc Qty Loc Code

ST -1

79120 7

ST242B 8

75181

76899

79119

79120

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| W/O: | | WORK ORDER CHANGES | | | | | |
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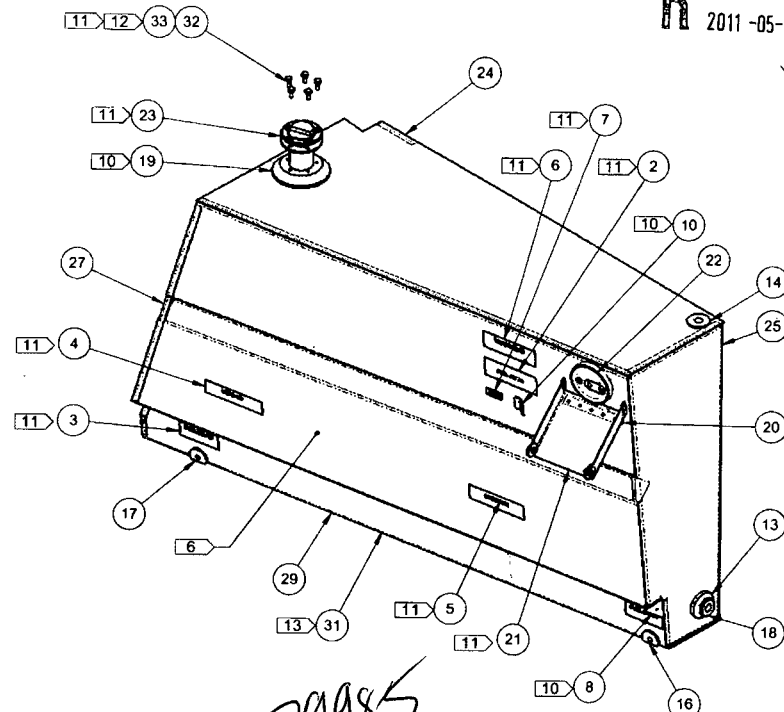
NOTE: Date & initial all entries

| ITEM NO. | QTY. .041 | PART NUMBER | DESCRIPTION |
|----------|--------------|---------------|------------------------------------|
| 1 | X | D4055-041 | FUEL TANK ASSEMBLY |
| 2 | 1 | D3997-1 | PLACARD "FUEL JET A1" |
| 3 | 2 | D3997-5 | PLACARD "AUX FUEL DRAIN" |
| 4 | 1 | D3997-11 | PLACARD "LOADING" |
| 5 | 1 | D3997-17 | PLACARD "STOWAGE" |
| 6 | 1 | D3997-29 | PLACARD "WARNING" |
| 7 | 1 | D3997-43 | PLACARD "EARTH" |
| 8 | 1 | D3999-7 | CORNER |
| 9 | 1 | D3999-9 | ANGLE |
| 10 | 1 | D3999-11 | EARTH TAB |
| 11 | 1 | D3999-041 | BAFFLE ASSEMBLY, AFT |
| 12 | 1 | D3999-043 | BAFFLE ASSEMBLY, FWD |
| 13 | 1 | D4000-1 | FUEL SUPPLY FITTING |
| 14 | 1 | D4000-5 | FUEL TANK VENT FITTING |
| 15 | 3 | D4000-9 | GROMMET |
| 16 | 1 | D4000-041 | AFT FUEL SUMP DRAIN ASSEMBLY |
| 17 | 1 | D4000-043 | FORWARD FUEL SUMP DRAIN ASSEMBLY |
| 18 | 1 | D4000-045 | FUEL PICK UP AND STRAINER ASSEMBLY |
| 19 | 1 | D4001-1 | FITTING |
| 20 | 1 | D4008-11 | TANK HINGE HALF |
| 21 | 1 | D4008-041 | FUEL FILLER SPLASH GUARD ASSEMBLY |
| 22 | 1 | D4023-3 | FUEL CAP |
| 23 | 1 | D4025-1 | FUEL SENDER |
| 24 | 1 | D4055-1 | TANK TOP |
| 25 | 1 | D4055-3 | TANK AFT END |
| 26 | 1 | D4055-5 | TANK UPPER CUT OUT |
| 27 | 1 | D4055-7 | TANK FORWARD END |
| 28 | 1 | D4055-9 | TANK BACK |
| 29 | 1 | D4055-11 | TANK FRONT AND BOTTOM |
| 30 | 3 | D4057-1 | RETAINING RING |
| 31 | 1 | D4404-1 | CUSHION |
| 32 | 5 | AN3H5A | BOLT |
| 33 | 5 | NAS1149D0363J | WASHER |

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: TOUCH UP CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-041" USING D2729-1 RED DECAL
- 7) WEIGHT: 27.57 lbs
- 8) WELD PER DART QSI 004
- 9) CAP ALL TANK ACCESS POINTS AND PRESSURIZE TANK TO 1.5 PSI AFTER ASSEMBLY. VERIFY NO LEAKS
- 10) MASK PRIOR TO POWDER COAT
- 11) INSTALL AFTER POWDER COAT. REMOVE TEXTURED FINISH LOCALLY PRIOR TO INSTALLATION
- 12) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
- 13) INSTALL CUSHION AFTER POWDER COAT USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED.

D4055-041 FUEL TANK ASSEMBLY



RELEASED
2011-05-30

| | | |
|------------|---|----------|
| B | MOVE CAP POSITION AND CHANGE CAP DESIGN, CHANGE FINISH REQUIREMENTS FOR ALL PARTS, ADD CUSHION UNDER TANK, CORRECT PART NUMBERS | 11.05.12 |
| A | NEW ISSUE | 10.04.16 |
| REV. | DESCRIPTION | BY DATE |
| DESIGN | | |
| DRAWN | | |
| CHECKED | | |
| MFG. APPR. | | |
| APPROVED | | |
| DE APPR. | | |
| DATE | 11.05.12 | |

| | |
|--|-------------------------|
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWING NO. D4055 | REV. B SHEET 1 OF 15 |
| TITLE TANK | SCALE NTS |
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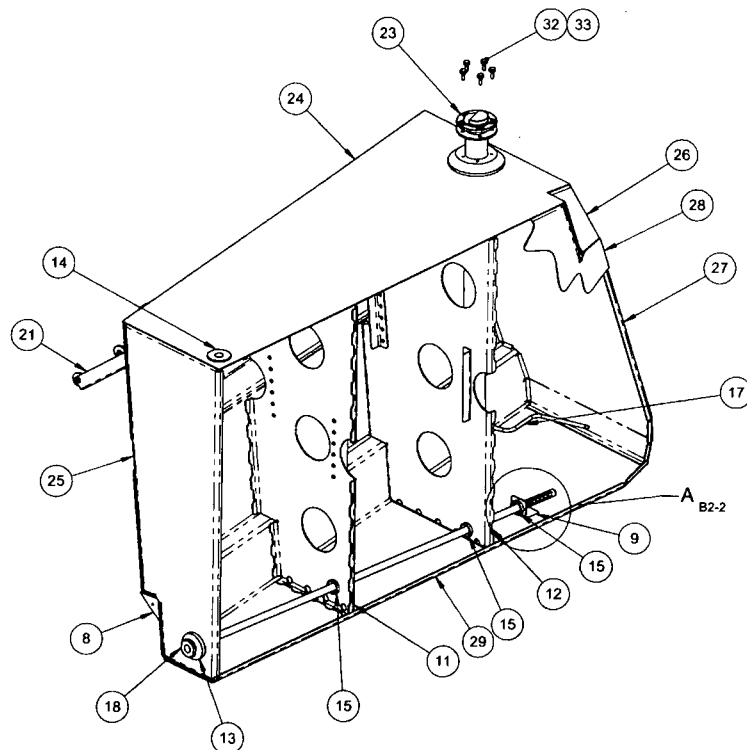
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

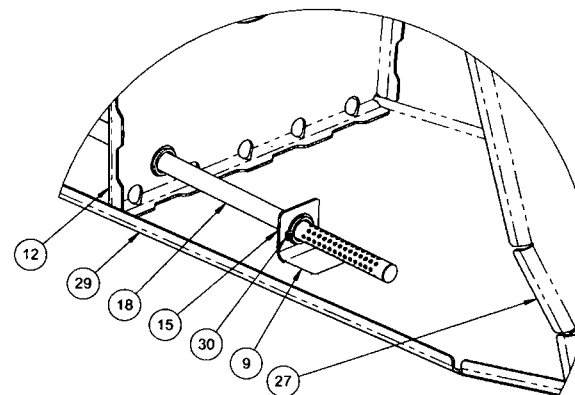
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D4055-041 FUEL TANK ASSEMBLY
D4055-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL



DETAIL A
ROTATED FOR CLARITY
SCALE 2X

B6-2

#79985

| | | | |
|------------|-----------------|--|---------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D4055 | SHEET 2 OF 15 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | TANK | NTS |
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 2011-05-30
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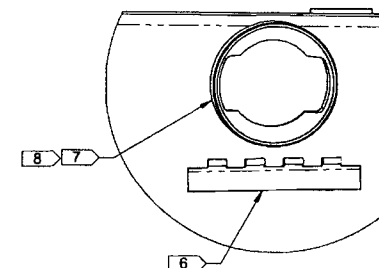
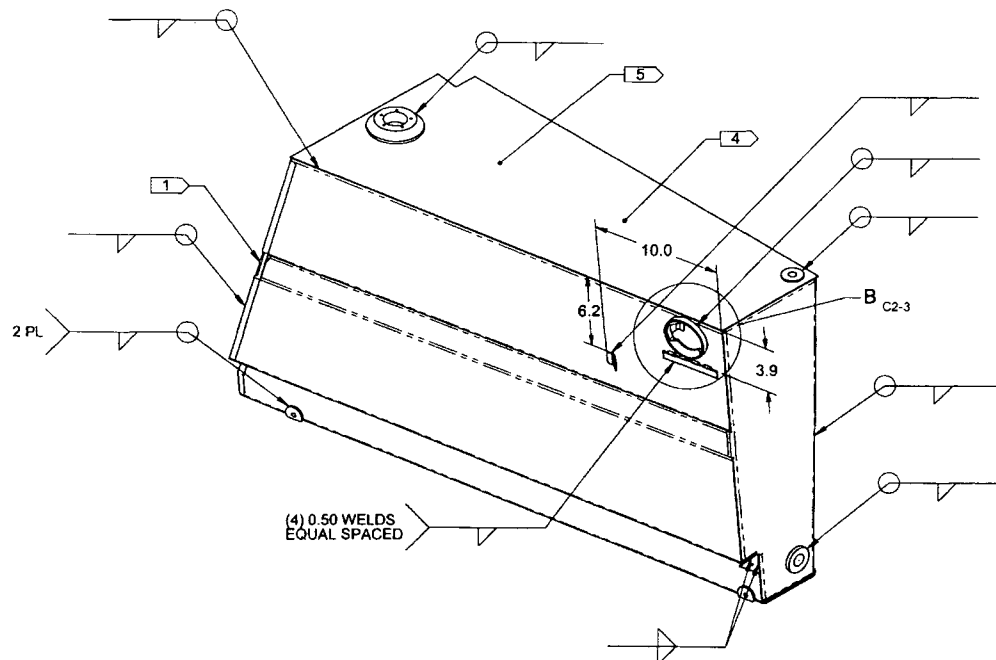
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NOTE: Date & initial all entries



DETAIL B
ROTATED FOR CLARITY
SCALE 2X

C4-3

D4055-041 FUEL TANK ASSEMBLY
WELDING DETAIL

NOTES:

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED
 - END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
 - FWD AND AFT DRAIN TUBES EXTEND TO CENTER OF TANK
 - ALL SWARF REMOVED
- 3) AFTER FINAL ASSEMBLY, SLOSH TANK WITH MIL-S-4383 OR EQUIVALENT (PR-1005-L BUNA-N-SLOSH)
- 4) ACCEPTABLE TO DRILL 6 (TYP) $\varnothing 0.312$ HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) ACCEPTABLE TO DRILL 7 (TYP) $\varnothing 0.312$ HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
- 6) CENTER HINGE BELOW FUEL CAP FLANGE
- 7) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 8) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK

79985

RELEASED
2011-05-30

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| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D4055 | REV. B |
| MFG. APPR. | | SHEET 3 OF 15 | |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | TANK | NTS |
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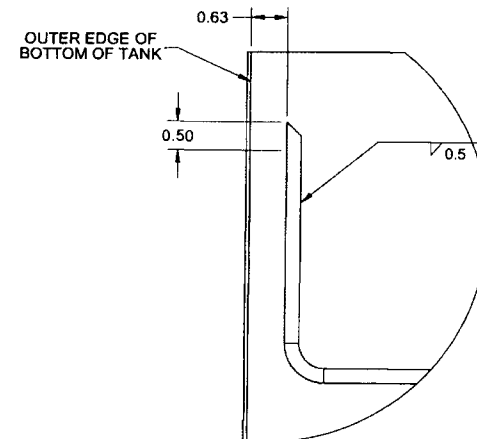
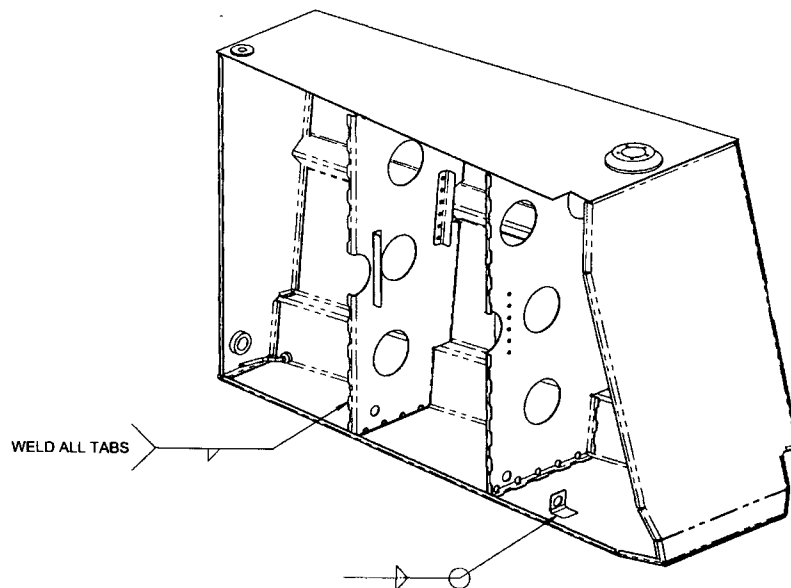
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NOTE: Date & initial all entries



DRAIN TUBE INSTALLATION - TYP
VIEWED FROM ABOVE
FWD END SHOWN, AFT END OPPOSITE

D4055-041 FUEL TANK ASSEMBLY
WELDING DETAIL

#79985

RELEASED
 2011-05-30
 JMT

| | | | |
|------------|----------|---|---------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
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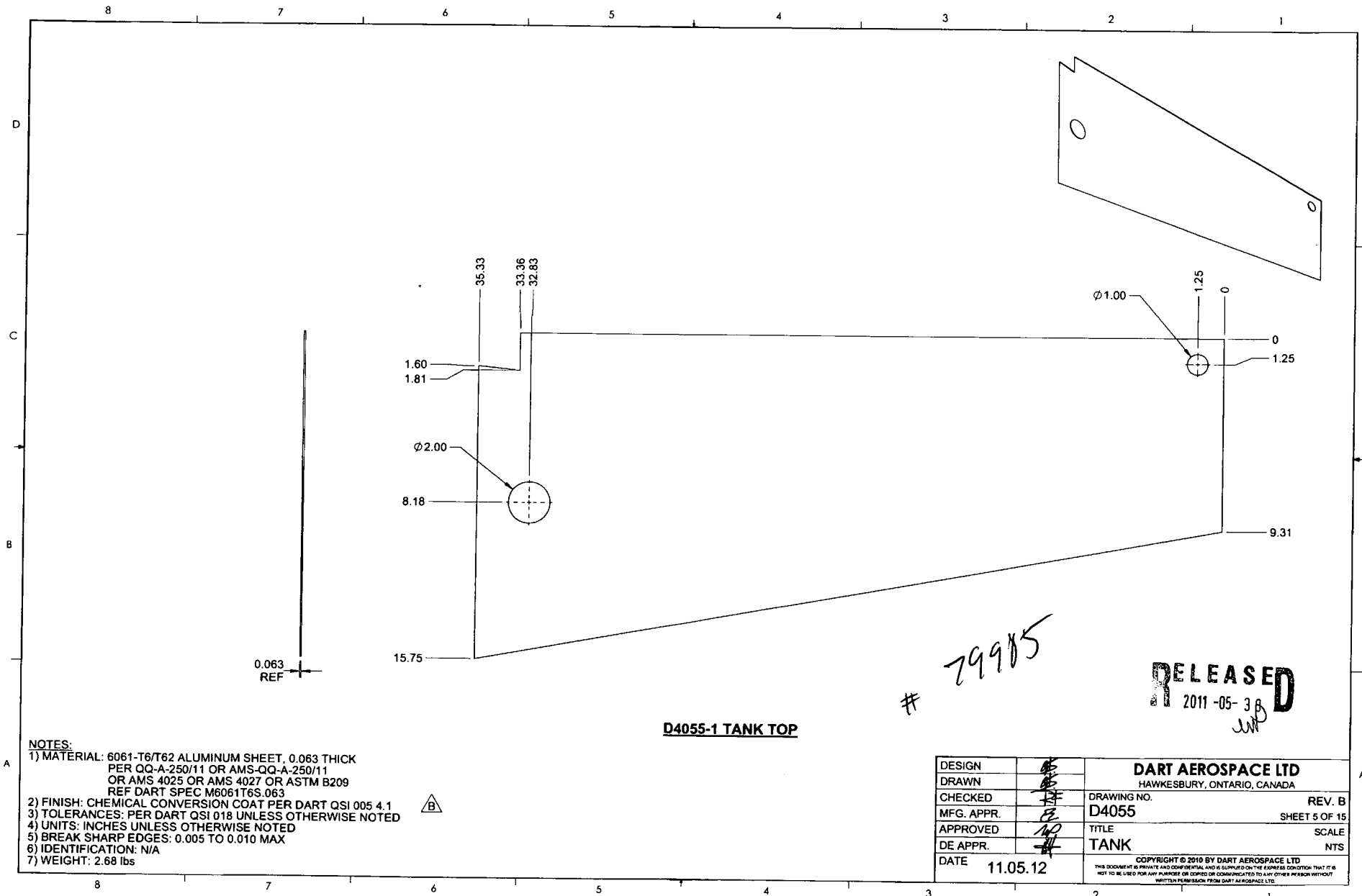
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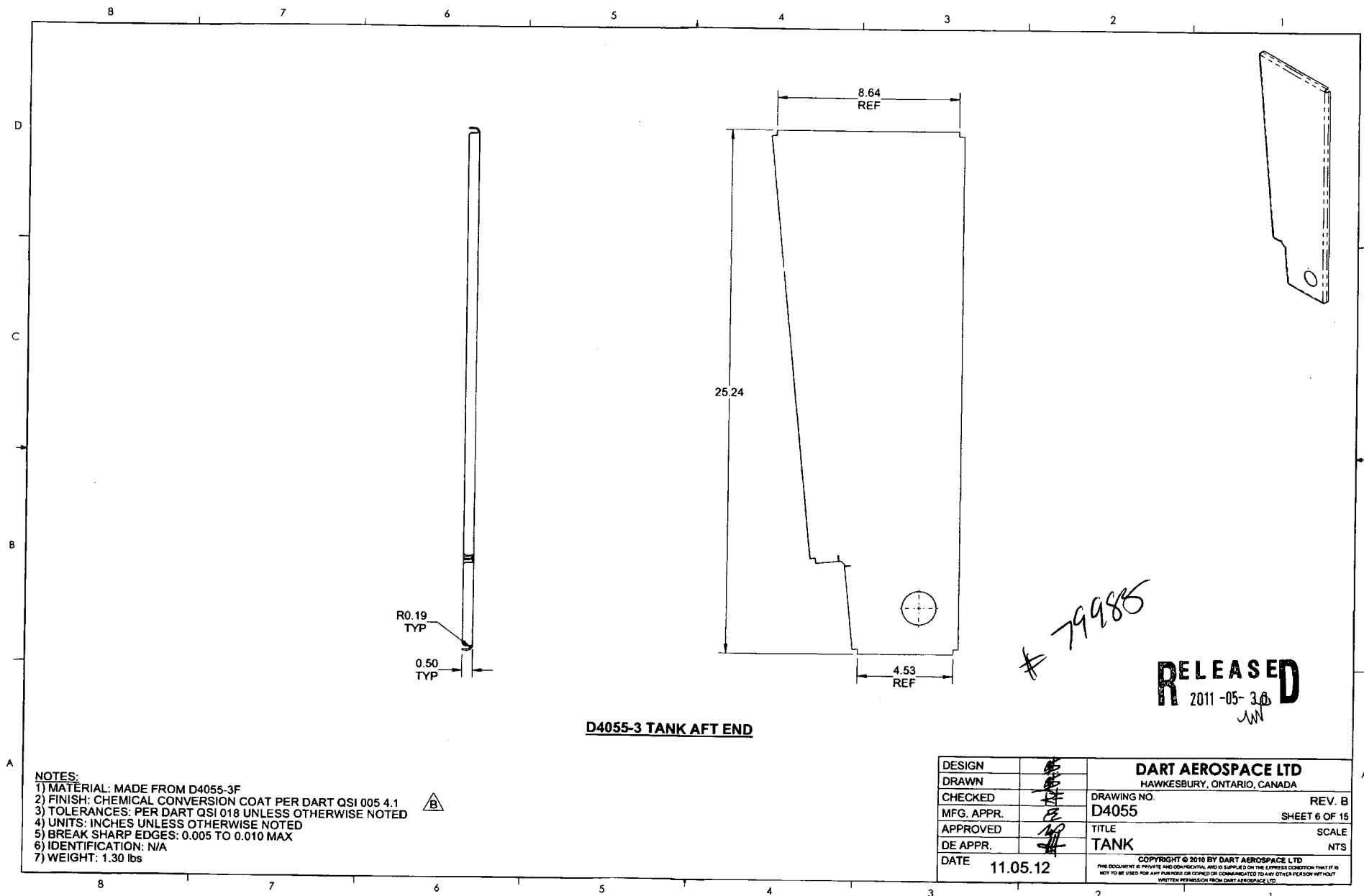
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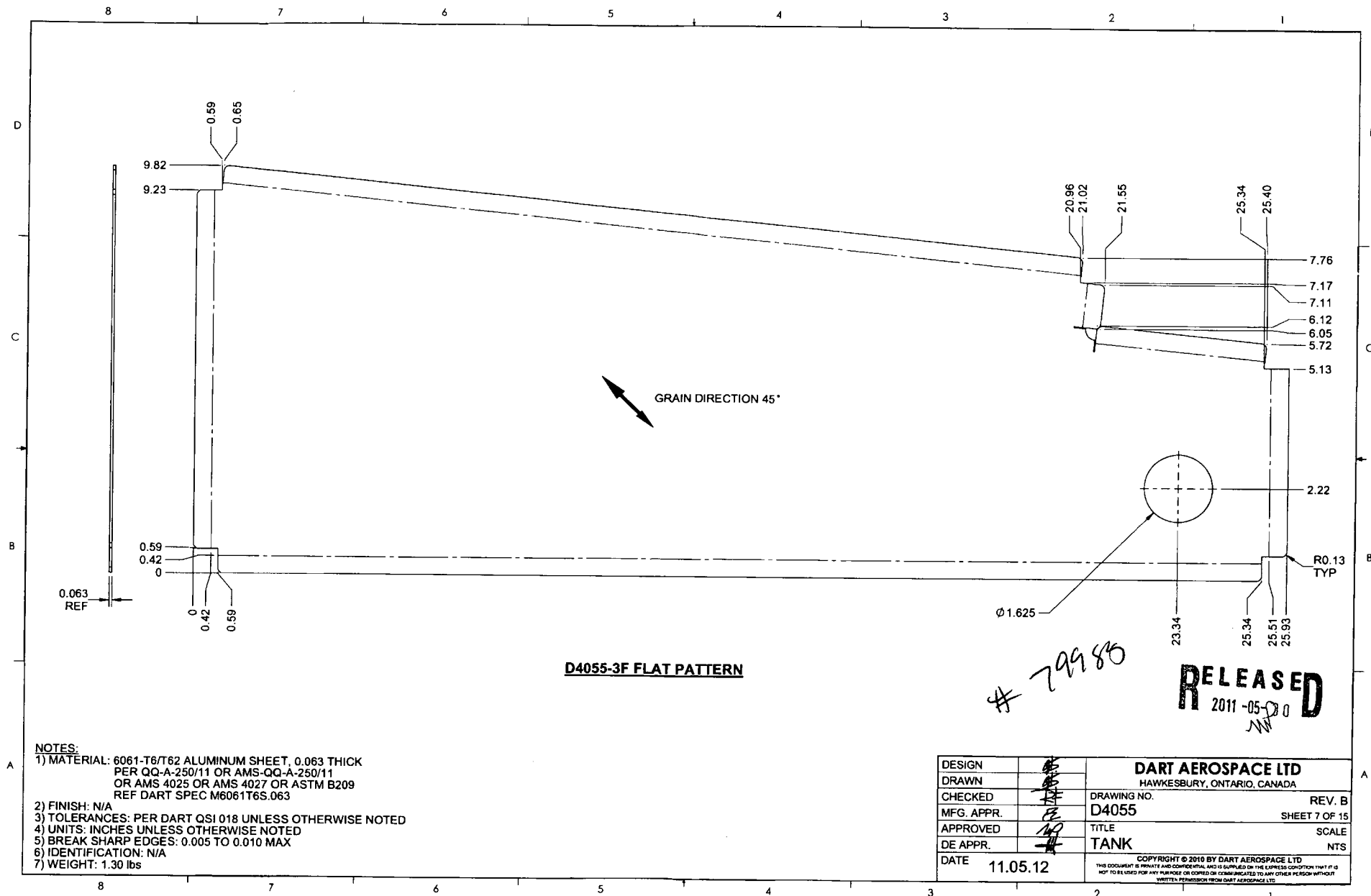
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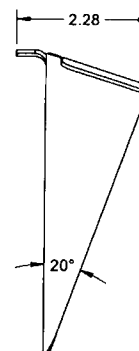
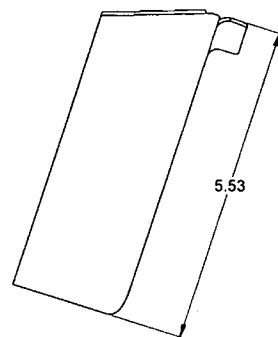
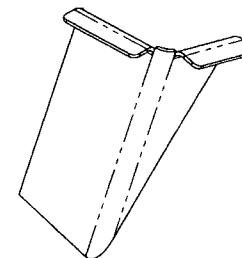
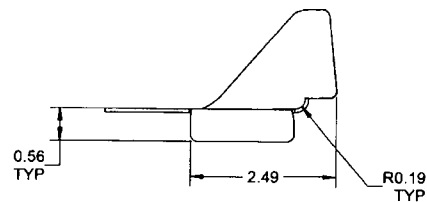
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



79985

D4055-5 UPPER CUT OUT

RELEASED
2011-05-30
NN

- NOTES:
- 1) MATERIAL: MADE FROM D4055-5F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.10 lbs



| | | | | |
|---|----------|--|--|---------------|
| DESIGN | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | | | | |
| CHECKED | | | DRAWING NO. | REV. B |
| MFG. APPR. | | | D4055 | SHEET 8 OF 15 |
| APPROVED | | | TITLE | SCALE |
| DE APPR. | | | TANK | NTS |
| DATE | 11.05.12 | | COPYRIGHT © 2010 BY DART AEROSPACE LTD | |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

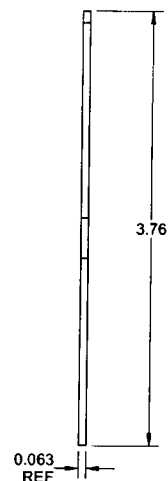
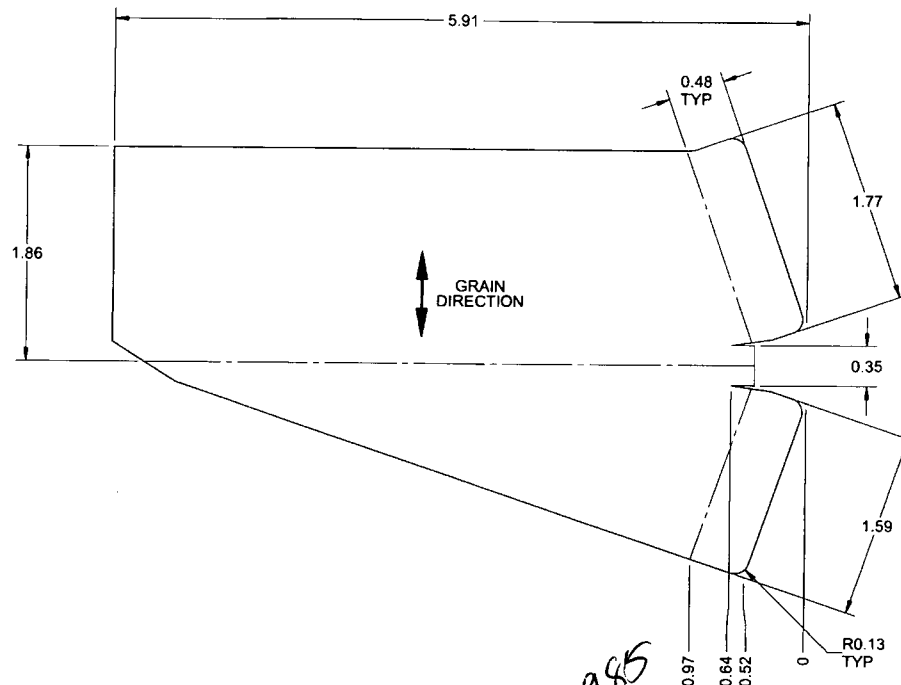
D4055-5F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

| | | | |
|------------|----------|--|---------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D4055 | SHEET 9 OF 15 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | TANK | NTS |
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RELEASED
2011-05-30



79985

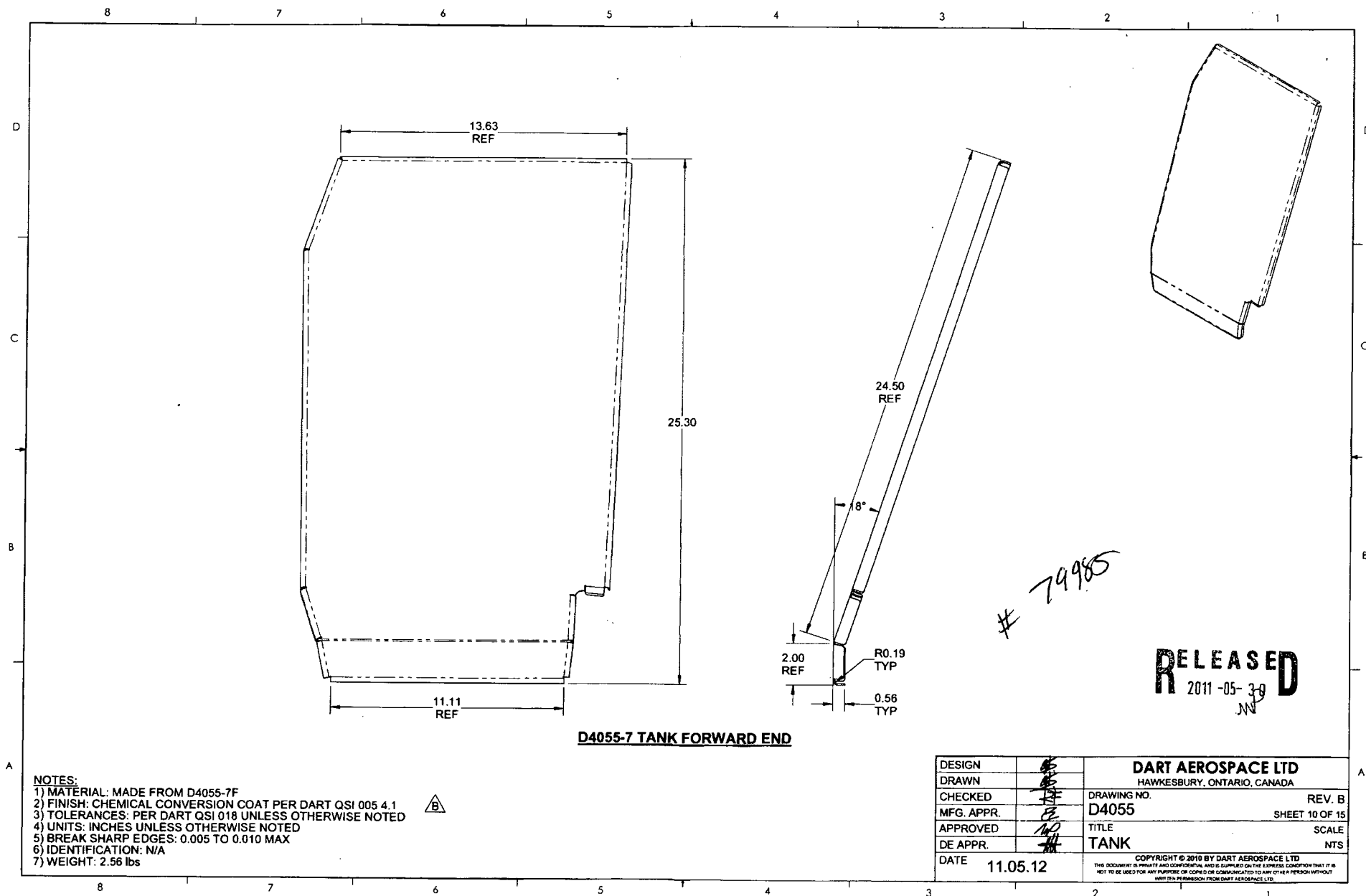
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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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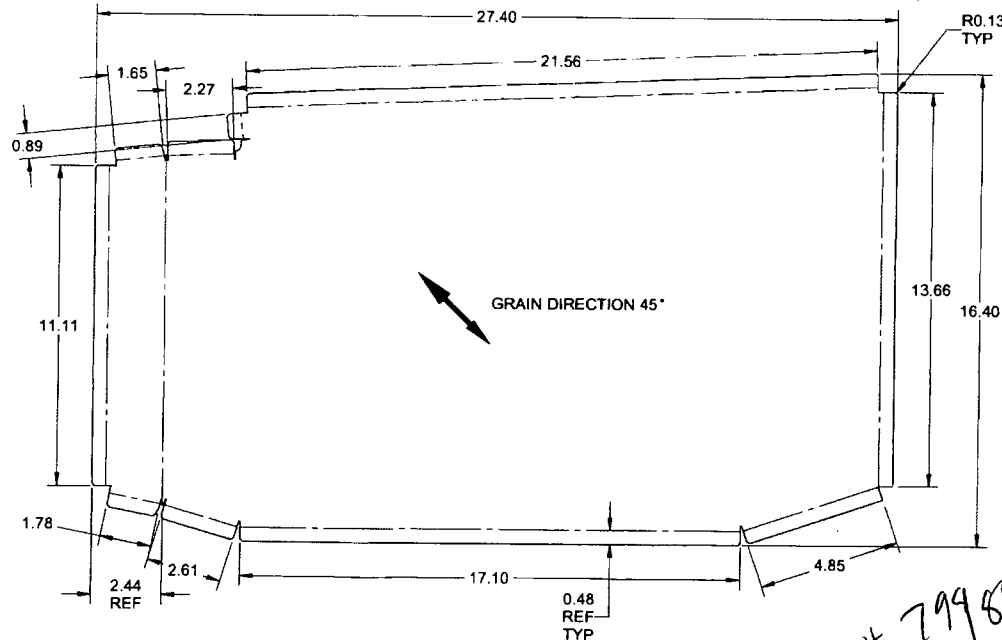
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0.063
REF









D4055-7F FLAT PATTERN

79985

RELEASED
R 2011-05-30

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs

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|--|---|--|----------------|
| DESIGN |  | DART AEROSPACE LTD | |
| DRAWN |  | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. B |
| MFG. APPR. |  | D4055 | SHEET 11 OF 15 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | TANK | NTS |
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8 7 6 5 4 3 2 1

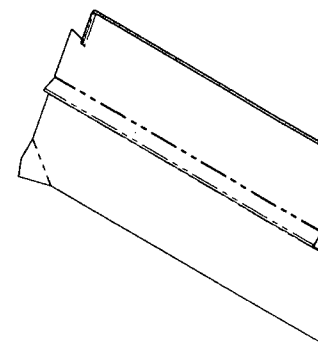
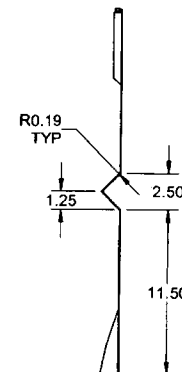
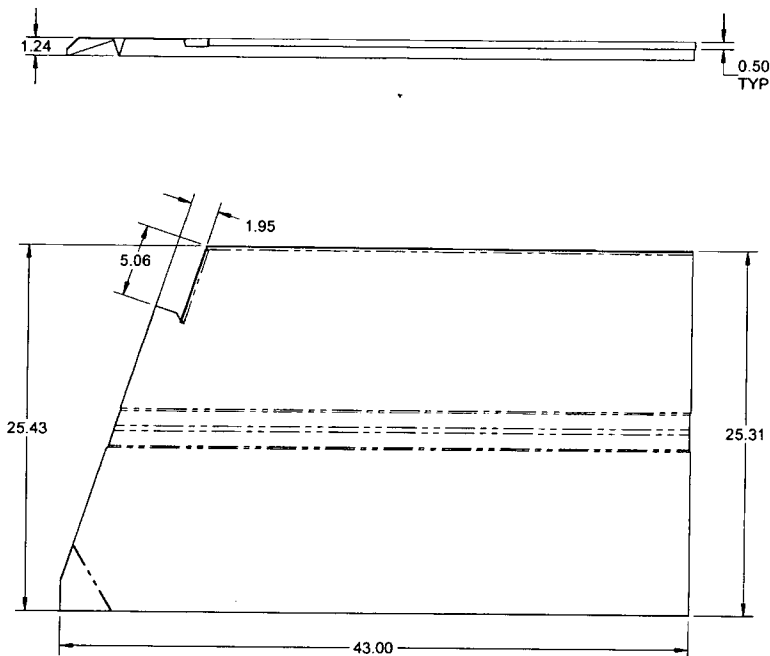
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



D4055-9 TANK BACK

RELEASED
2011-05-30
JW

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-9F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 6.41 lbs



| | | | |
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| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D4055 | REV. B |
| MFG. APPR. | | SHEET 12 OF 15 | |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | TANK | NTS |
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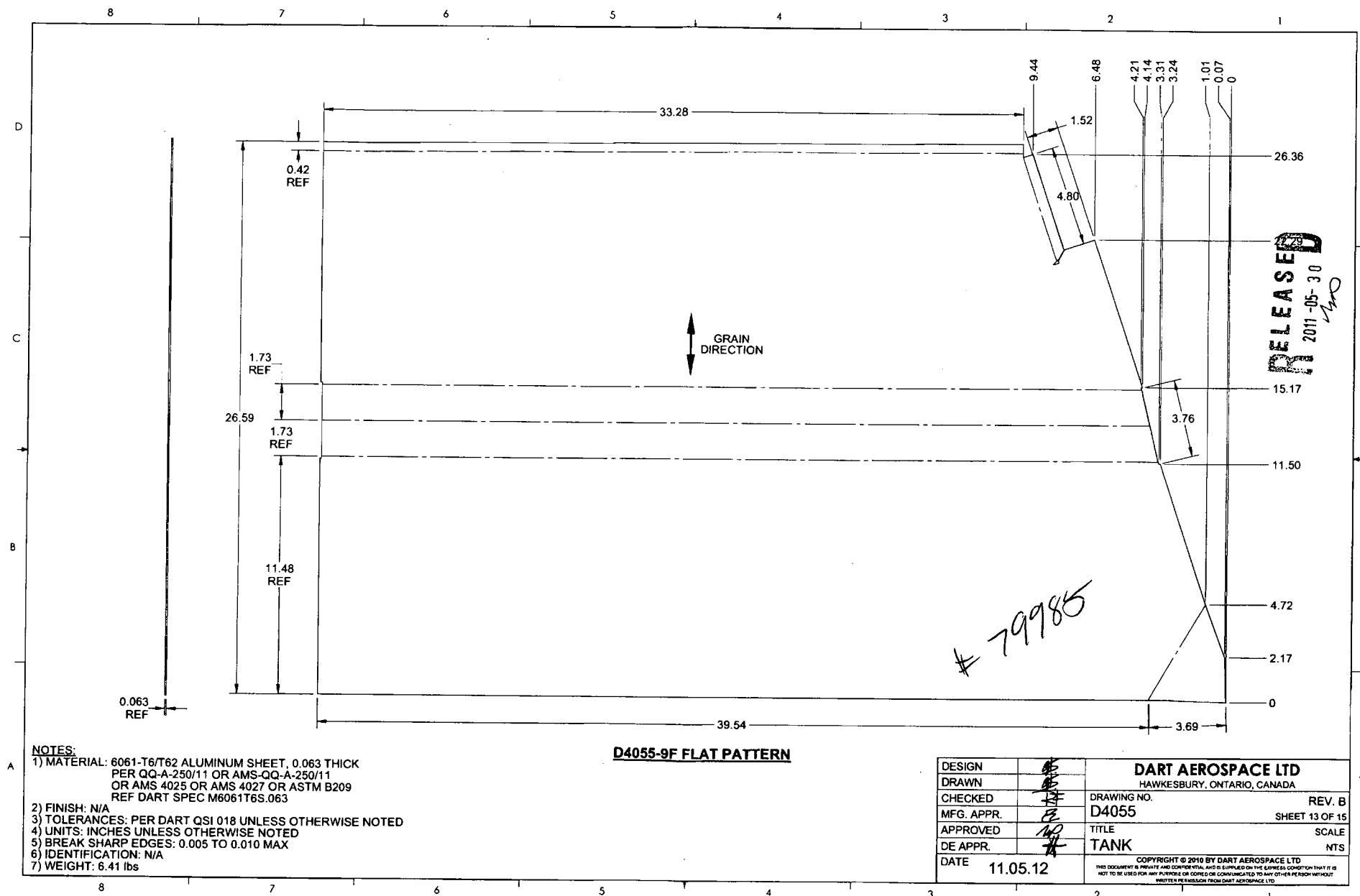
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



2011-05-30
RELEASED

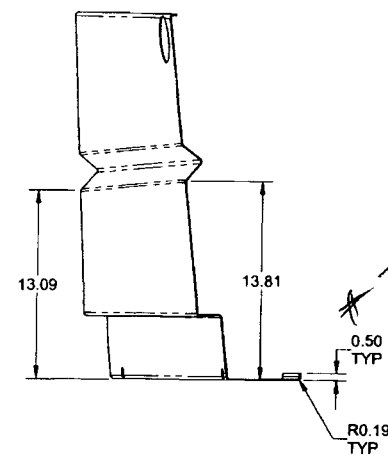
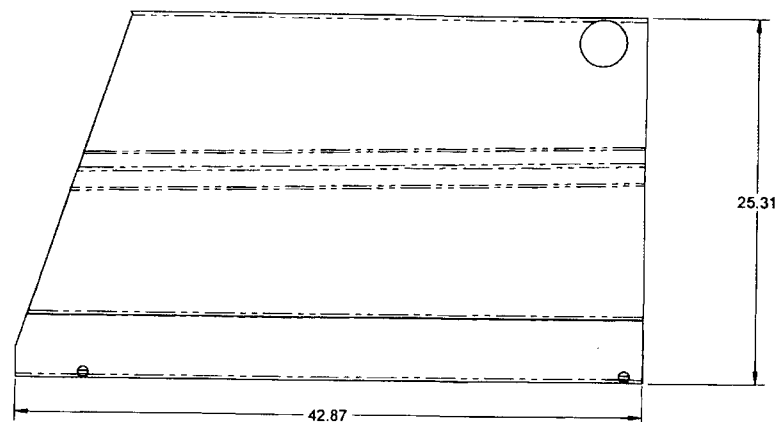
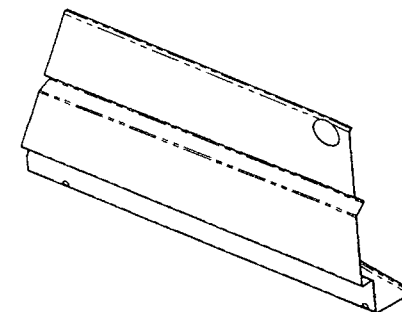
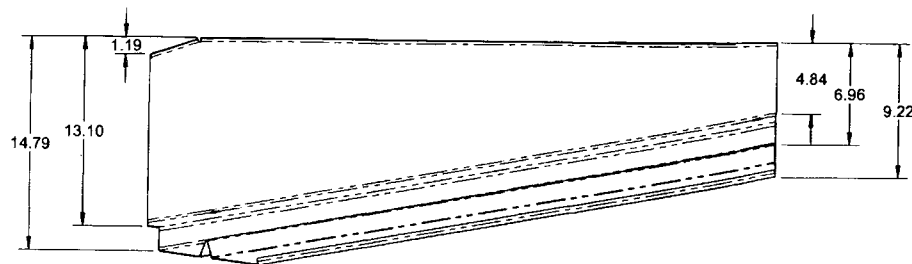
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



D4055-11 TANK FRONT AND BOTTOM

- NOTES:
- 1) MATERIAL: MADE FROM D4055-11F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 9.32 lbs



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| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D4055 | REV. B |
| MFG. APPR. | | SHEET 14 OF 15 | |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | TANK | NTS |
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RELEASED
2011-05-30

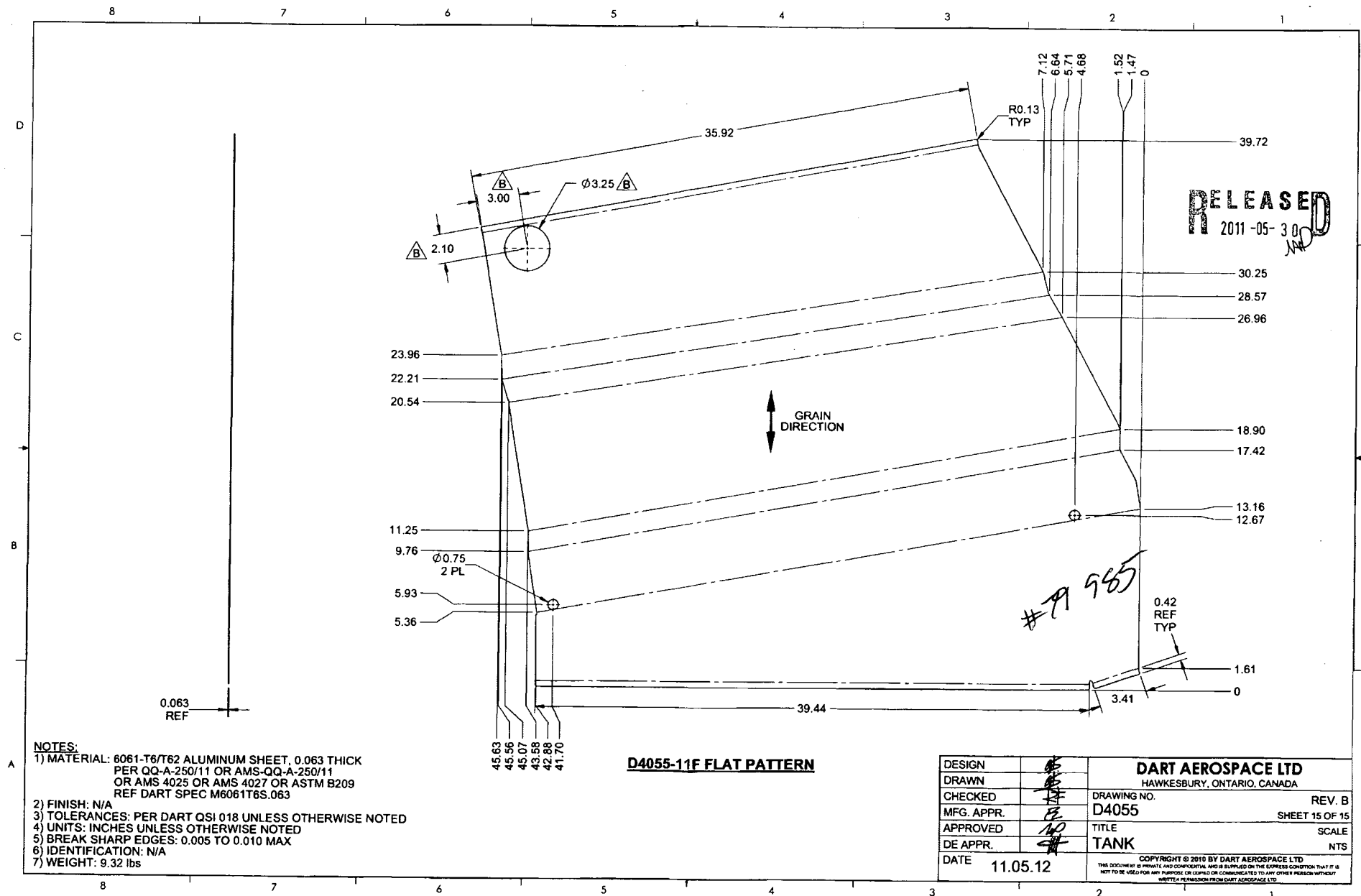
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries